

Date: Wednesday, 1/4/2006 2:36:38 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L BASKET BASE  
 Job Number : 25389A  
 Estimate Number : 11273  
 P.O. Number : N/A  
 This Issue : 1/4/2006 S.O. No. : N/A  
 Prsht Rev. : NC  
 First Issue : N/A Type : LARGE FAB ASSY  
 Previous Run : 23136A  
 Part Number : D2252041  
 Drawing Number : UNDER REVIEW D2252 REV. E  
 Project Number : N/A  
 Drawing Revision : E  
 Material : N/A  
 Due Date : 1/30/2006 Qty: 1 Um: Each  
 Written By : SEE COMMENT BELOW  
 Checked & Approved By : SEE ABOVE USER & DATE  
 Comment : Est Rev: I Revised as per Rev E 05-12-06 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D31661 Basket Hoop



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part# Description Batch  
 5 D3166-1 Hoop B25844

⑤

06/03/08

2.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 25.0000 f(s)/Unit Total : 25.0000 f(s)

3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Batch: M100023

25

06/03/08

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Cut 5 D2235-1 From D3166-1

2- Cut Ribs as per Dwg D2252

3-Drill hole in D2252-1as per Dwg D2252

4-Deburr & Remove all Markings from Material

①

06/03/08

4.0 D22531 Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch  
 2 D2253-1 Gusset B12413

②

06/03/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: 206L BASKET BASE

Job Number: 25389A

Part Number: D2252041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D23273

Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2327-3 Bushing B24874

(1)

06/03/08

6.0

D2581

Mounting Bracket



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2581 Mounting Chancel B25834

(4)

06/03/13

7.0

D2254

Gusset for D206bskt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2254 Lug B23421

(2)

06/03/08

8.0

D22323

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2232-3 HINGE B24527

(2)

06/03/08

9.0

D22531

Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D22531 LUG

06/03/08

10.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 33.6000 sf(s)/Unit Total : 33.6000 sf(s)

Pick:

Qty Part Number Description Batch

32 sf M304EX0.75-16F Expanded Metal M100230

32 sf

06/03/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 206L BASKET BASE

Job Number: 25389A

Part Number: D2252041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2252 using Welding Table and corner Jig Debur as required

A/R SS ROD Batch: M19555

AD 06/03/08 ①

12.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PD 06-03-16 ①

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/03/16 ①

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

26-03-17

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

C 30/03/20 ①

16.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/03/23 ①

Job Completion



U 06-03-22

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ \_\_\_\_\_ Date: 04/03/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED  
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DESIGN KE	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2252	REV. E SHEET 1 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206L)	SCALE NTS
C	95.12.11	RE-DRAWN	
D	99.09.14	MODIFIED LATCH, D2581 WAS D2255-3	
E	05.11.10	D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS TO LID FRAME, ADDED D2232-1/-3 & D2252-19	

E

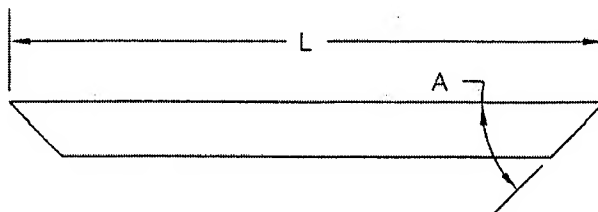
E

E

Qty -041	Qty -043	Part Number	Description	L	A
X		D2252-041	BASKET ASSEMBLY		
	X	D2252-043	LID ASSEMBLY		
	2	D2232-1	HINGE		
2		D2232-3	HINGE		
5		D2235-1	RIB		
2	2	D2252-1	FRAME	25.50	45
2		D2252-3	FRAME	96.00	45
	2	D2252-7	FRAME	24.00	90
1		D2252-9	FRAME	10.25	90
1		D2252-11	FRAME	25.00	90
1		D2252-13	FRAME	42.00	90
1		D2252-15	FRAME	15.00	90
4		D2252-17	FRAME	19.78	53
	2	D2252-19	FRAME	95.27	45
	2	D2252-21	FRAME	30.82	90
	1	D2252-23	FRAME	30.62	90
2		D2253-1	LUG		
2		D2254	GUSSET		
	1	D2327-1	BUSHING		
1		D2327-3	BUSHING		
	1	D2329	LABEL PLATE		
4	2	D2581	MOUNTING CHANNEL		
A/R	A/R		3/4-16F EXPANDED METAL		

NOTES:

1. MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE  
(REF. DART SPEC. M304TS0.750W.060)
2. FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3. WELD PER DART QSI 004
4. ALL DIMENSION ARE IN INCHES
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



CUT SIZE DETAIL

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DATE

25389 A

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KE	MB		
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<i>[Signature]</i>	<i>[Signature]</i>	D2252	SHEET 2 OF 5
DATE		TITLE	SCALE
05.11.10		BASKET ASSEMBLY (206L)	NTS

D2232-1 (TYP BOTH ENDS)

A

A

29.64

34.50

29.64 (REF)

D2581

D2581

D2327-1 (REF) SEE DETAIL F

D2252-1

30.82

D2252-19

D2252-7

D2252-21

D2252-23

D2252-1

95.27<sup>+0.00</sup><sub>-0.01</sub>

WELD ALL JOINTS  
AS SHOWN

25389A

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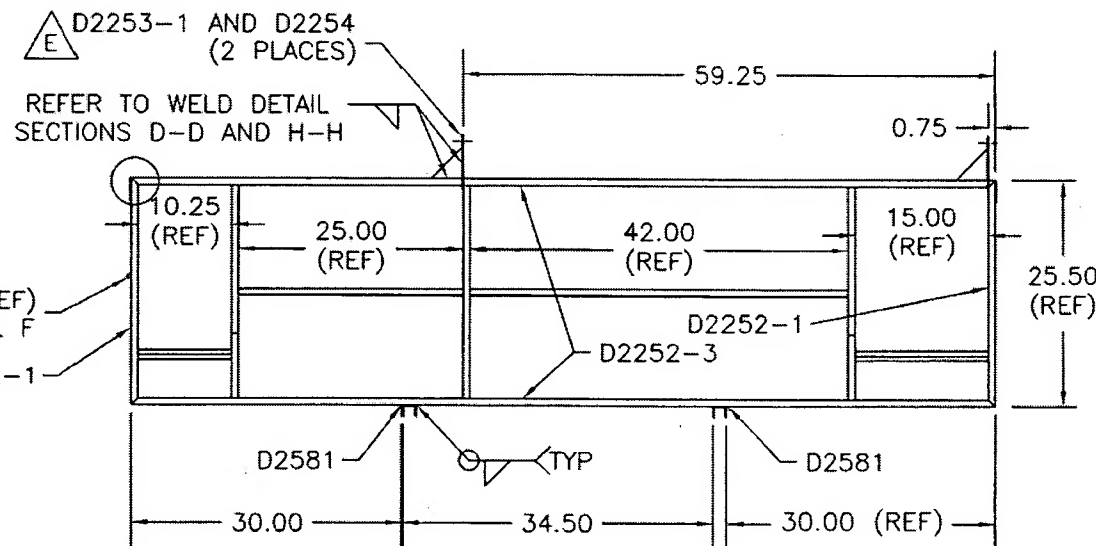
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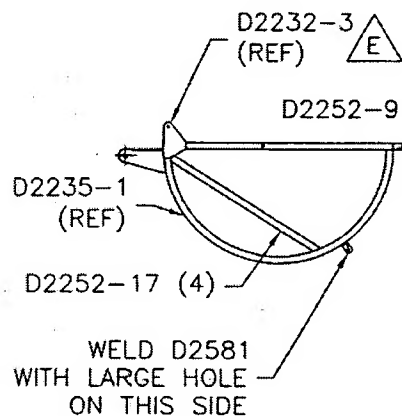


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CHECKED		APPROVED		DRAWING NO. D2252
DATE	05.11.10	TITLE	BASKET ASSEMBLY (206L)	REV. E SHEET 3 OF 5
		SCALE	NTS	



WELD ALL JOINTS  
AS SHOWN



WELD D2581  
WITH LARGE HOLE  
ON THIS SIDE

D2252-041 BASKET FRAME

**RELEASED**  
05.11.26

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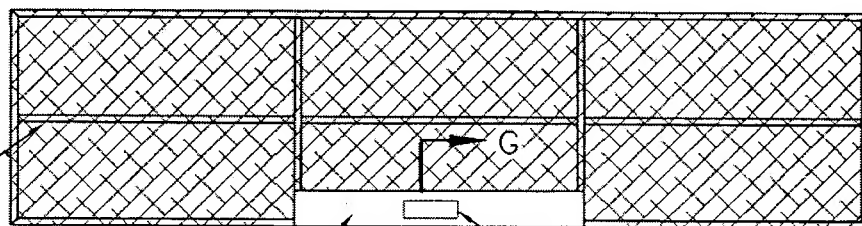
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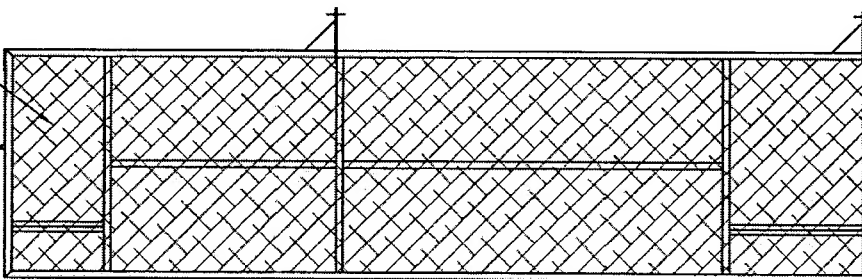
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DATE	05.11.10	TITLE	BASKET ASSEMBLY (206L)	REV. E SHEET 4 OF 5
		SCALE	NIS	



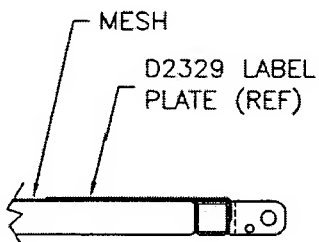
D2329 LABEL PLATE  
CENTER ON THE  
BASKET LID

REMOVE 2" X 6" SECTION  
OF MESH FROM BEHIND  
LABEL PLATE

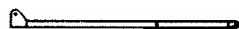
D2252-043 LID ASSEMBLY



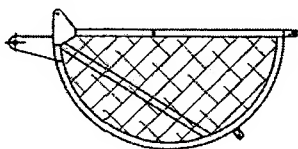
D2252-041 BASKET ASSEMBLY



SECTION G-G



SKIN WITH 3/4-16 F  
EXPANDED SS, TACK  
WELD EACH STRAND  
END TO FRAME

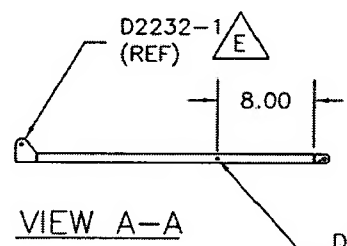
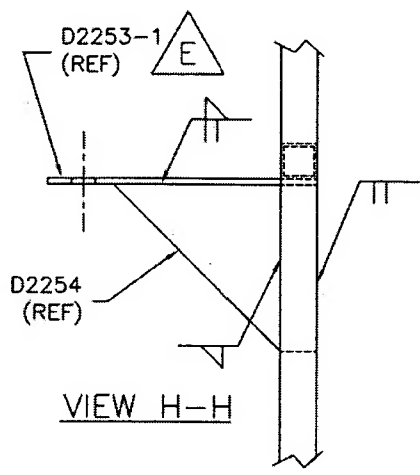
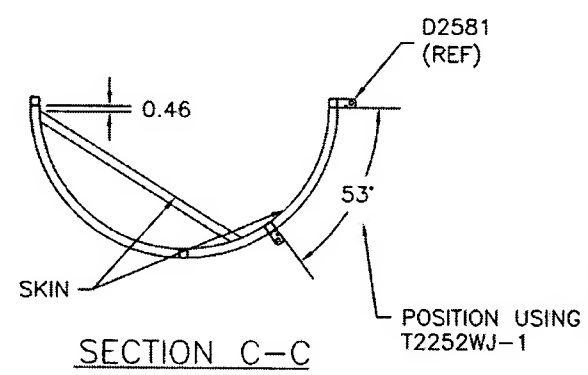
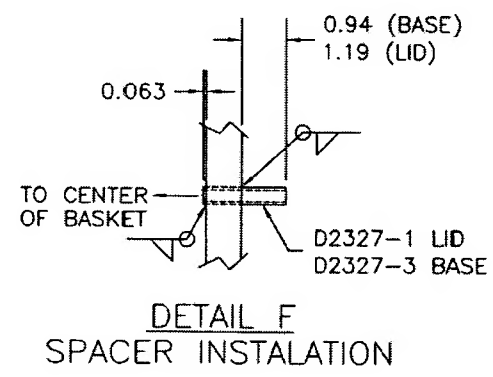
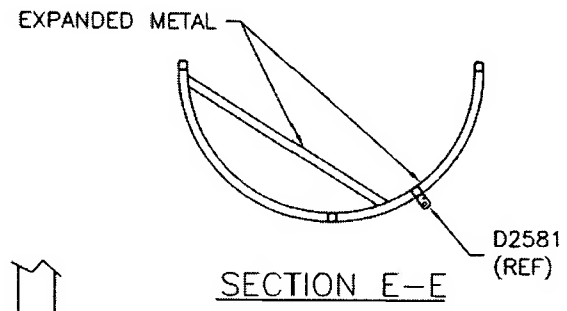


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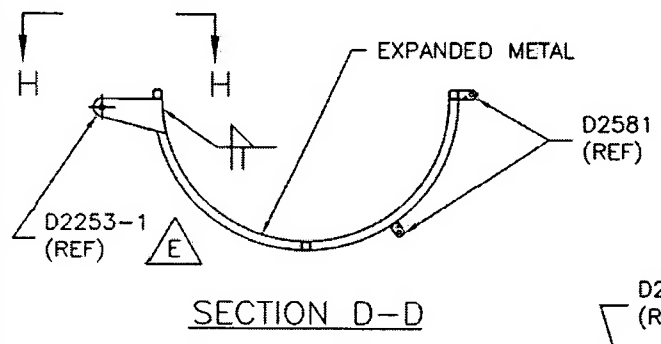
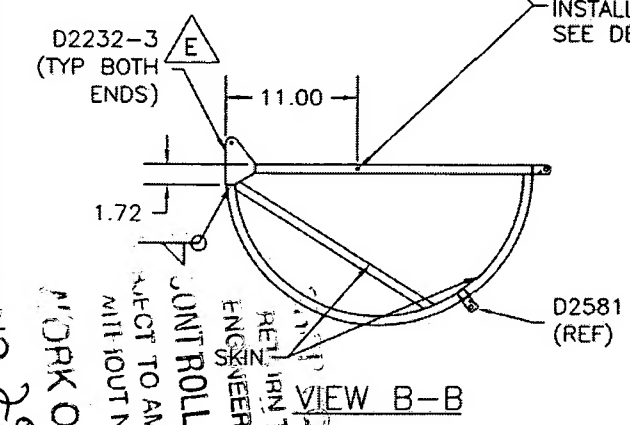
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	REV. E
DATE	05.11.10	TITLE	D2252	SHEET 5 OF 5
			BASKET ASSEMBLY (206L)	SCALE NTS



DRILL 3/8 HOLE AND  
INSTALL D2327-1/-3  
SEE DETAIL F



**RELEASED**  
05.11.26

WORK ORDER  
25389A

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